

Work Order ID **67153**



Page 1

Wednesday, March 09, 2011 12:50:24 PM

Item ID: D206-642-341

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 3/9/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/18/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-03-9

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2650

F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-341 CHG003

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Deburr Fwd edge of tube								
	2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650								
	3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.								
	A/R <input type="checkbox"/> Aluminum Rod <input type="checkbox"/> M111385 / M116577 BE 11/04/07								
	4-Grind weld flush to cap on top surface only. BE 11/04/07								
	5-Cut aft end to length as per dwg D2650								
	6-Drill pilot holes using drill Jig DT8168A (A, & B) and DT8025. Open to Ø0.312"								
	7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297"								
	8-Open Aft Cap Hole using #6 Drill Bit								
	9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail								
	10-Remove inner indexing ridge on aft end of skidtubes as per Dwg D2650								
	11-Deburr and Blow out all chips from inside the tube								

> DP

11-4-6

3

BE 11/04/08

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

115

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sulaclos

44

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

BB
11/04/08

125

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

DP

11-4-8

W/O:		WORK ORDER CHANGES					
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Customer:

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



Skidtubes

0.00

Skidtubes

Memo1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail
(without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-5 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs.
cure time before cutting ☐Start Date: 11-4-8 ☐ Time: 3:15 ☐Finish Date: _____ ☐ Time: ☐A/R ☐ Sikaflex-291 ☐ 1116948 ☐

Sikaflex expiry date: 12-1-13

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11-4-8

1 Ø BEU/offs

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod A/R ☐ Aluminum Rod ☒ *mill 385* *BE 11/04/12*

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Debur

4- Install nut plate as per dwg

170

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

*11.04.12**1* *φ*

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

MA 11 04 13 (1)

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

1 BR 11-4-13.

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

M116964
START TIME: 2:15
OVEN TEMPERATURE: 320°
FINISH TIME: 2:451 BR 11-4-13.

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 0 24 110414

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	HandFinishing	0.00							
 HandFinish	Memo	0.00				1	0	22	11/04/14
Hand Finishing	1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. ✓ A/R <input type="checkbox"/> Sikaflex-291 <input checked="" type="checkbox"/> <u>1116918</u> Sikaflex expiry date: <input type="checkbox"/> <u>0112</u>								
	2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive								
	3-Install MS27039-4-06 Screw as per DEO 9153								
	4-Inspect for foreign object per QSI 024								
	5-Install D2646 A.1 Cap and seal with SikaflexClean excess adhesive ✓ A/R <input type="checkbox"/> Sikaflex-291 <input checked="" type="checkbox"/> <u>1116918</u> Sikaflex expiry date: <input type="checkbox"/> <u>0112</u>								
	6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4 ✓ Batch: <u>1117315</u>								

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC3- Inspect Part Finish	0.00				<u>ml</u>	<u>11</u>	<u>04</u>	<u>15</u> (1)
QC	Memo	0.00							
Quality Control									
240	QC5- Inspect part completeness to step on W/O	0.00				<u>ml</u>	<u>11</u>	<u>04</u>	<u>15</u> (1)
QC	Memo	0.00							
Quality Control									
250	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-341								
	Location: _____								
	PPP Rev: <u>PPP 67146 (311)</u>								

Run/4/18 (1)

W/O:		WORK ORDER CHANGES					
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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/19
ME

11-04-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 1

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Parent Item Name: Replacement Skidtube



Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: H05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
 IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DS19440 rev.a DD verified by: EC IPP rev K 10.08.03 chg ms27039-1-08 for "C" type EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD416 Washer	NAS1149D04631	Purchased	No				Each	30.0000	1				

M116805



(x1) all 1104/18

Location	Loc Qty	Loc Code
ST300	24	
113288	24	
ST356	6	
115622	6	

CCR264SS3-3

Purchased

No

Each

332.0000

2



Cherry Rivet



BE11/04/12

Location	Loc Qty	Loc Code
ST311	332	
112314	4	
113539	44	
113973	88	
117086	196	

2

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Parent Item Name: Replacement Skidtube

Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

Each

1,837.000

2



Cherry Rivet



BBU/04/12

Location

Loc Qty

Loc Code

MEZZ

1837

110139

2

110153

35

111359

5

112314

2

114436

448

114450

31

114859

1314

2

D2620

Manufactured

No

Each

15.0000

1



Skidtube, 206 Skidtube



Location

Loc Qty

Loc Code

LG

15

62684

6

64784

9

D2647

Manufactured

No

Each

51.0000

1



Cap



① D 11-4-6

BBU/04/07

Location

Loc Qty

Loc Code

FP

51

55352

51

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Shop Packet Print

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Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

D2649 Manufactured No

Each 120.0000 19



Cross Bolt Spacer



BE 4/4/12

Location

Loc Qty

Loc Code

LG 120
58545 2
60652 4
61496 2
62889 11
63359 3
65317 98

19

D2654-5 Manufactured No

Each 2.0000 1



Web



Location

Loc Qty

Loc Code

LG 2
64878 2
B67675 Each 14.0000

11-4-8
BE 11/6/12

D2680-041 Manufactured No

Each 14.0000



Nut Plate



Location

Loc Qty

Loc Code

ST020 14
55366 14

1

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Shop Packet Print

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Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039C1-08

Purchased

No

Each

959.0000

56



SCREW



56
JL 4/10/14

Location

Loc Qty

Loc Code

FP

63

115336

63

ST293

896

115589

347

116022

148

116373

400

19185

1

X18
X38

ALS4-1032-130

Purchased

No

220

Each

759.0000

54

54



Insert



54
JL 4/10/14

Location

Loc Qty

Loc Code

PKG11

624

114723

42

116864

582

ST282

96

110511

10

115911

86

ST381

39

114654

39

M116800

X54

AN960C10L

NAS1149C0332

Purchased

No

220

Each

61.0000

54

54



washer



54
JL 4/10/14

Location

Loc Qty

Loc Code

ST297

61

107534

59

108246

2

M117291

X54

W/O:		WORK ORDER CHANGES					
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Work Order ID: 67153

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD10L NAS1149D0332J Purchased No

220 Each 4.0000 2 2



Washer

M117010



(x2) 11/05/14

Location

Loc Qty

Loc Code

ST335

4

11912

4

D2646 Manufactured No

220 Each 71.0000 1 1



Aft Cap



11/05/14

Location

Loc Qty

Loc Code

FP-4

1

57332

1

FP6

16

52663

3

62678

12

63633

1

Return 2010

54

62678

54

D2651-1 Manufactured No

220 Each 511.0000 14 14



Plug



11/05/14

Location

Loc Qty

Loc Code

FP

189

51530

152

62638

37

fpa

322

53349

205

57869

117

x14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Wednesday, March 09, 2011 12:50:31 PM

Work Order ID: 67153

Parent Item: D206-642-341



Parent Item Name: Replacement Skidtube

Start Date: 3/9/2011

Required Date: 3/18/2011



Start Qty: 1.00

Required Qty: 1.00

D2651-3	Manufactured	No	220	Each	404.0000	14	14
							<u>14</u> 11/04/14
O-Ring							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP	404	
46114	12	
<u>61962</u>	392	

D3535-11	Manufactured	No	220	Each	7.0000	1	1
							<u>1</u> 11/04/14
Wearshoe							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP019	7	
57261	1	
63676	6	

D3535-23	Manufactured	No	220	Each	18.0000	1	1
							<u>1</u> 11/04/14
Wearshoe							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP021	18	
63571	4	
66236	13	

D3535-35	Manufactured	No	220	Each	12.0000	1	1
							<u>1</u> 11/04/14
Wearshoe							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP018	12	
<u>65926</u>	12	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 7

Wednesday, March 09, 2011 12:50:31 PM

Work Order ID: 67153

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

D3536-11

Manufactured No

220 Each

19.0000

1

1



Gasket



all 11/04/11

Location

Loc Qty

Loc Code

FP011

15

57867

3

65574

12

ST497A

4

46715

4

X1

D3536-23

Manufactured No

220 Each

36.0000

1

1



Gasket



all 11/04/11

Location

Loc Qty

Loc Code

FP011

26

63570

1

66560

25

ST

10

66240

10

B43406

X1

D3536-35

Manufactured No

220 Each

16.0000

1

1



Gasket



all 11/04/11

Location

Loc Qty

Loc Code

FP012

16

58683

1

63579

1

65573

2

66237

12

X1

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Page 7

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Page 8

Wednesday, March 09, 2011 12:50:32 PM

Work Order ID: 67153

Parent Item: D206-642-341



Parent Item Name: Replacement Skidtube

Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

D3537-1	Manufactured	No	220	Each	29.0000	6	6
							<u>all 11/04/11</u>
Wearpad							

Location

Loc Qty

Loc Code

FP017

29

B65927



37749

6

X 10

65057

23

D3537-3	Manufactured	No	220	Each	26.0000	1	1
							<u>all 11/04/11</u>
Wearpad							

Location

Loc Qty

Loc Code

FP17



26

B35692
B61674

65929

26

X 1

MS27039-4-06	Purchased	No	220	Each	91.0000	1	1
							<u>all 11/04/11</u>
Screw							

Location

Loc Qty

Loc Code

ST292

91

109061

4

X 1

115460

87

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

F

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL .20.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67153

PL 11-03-9

RELEASED
08-07-23

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 259).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
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DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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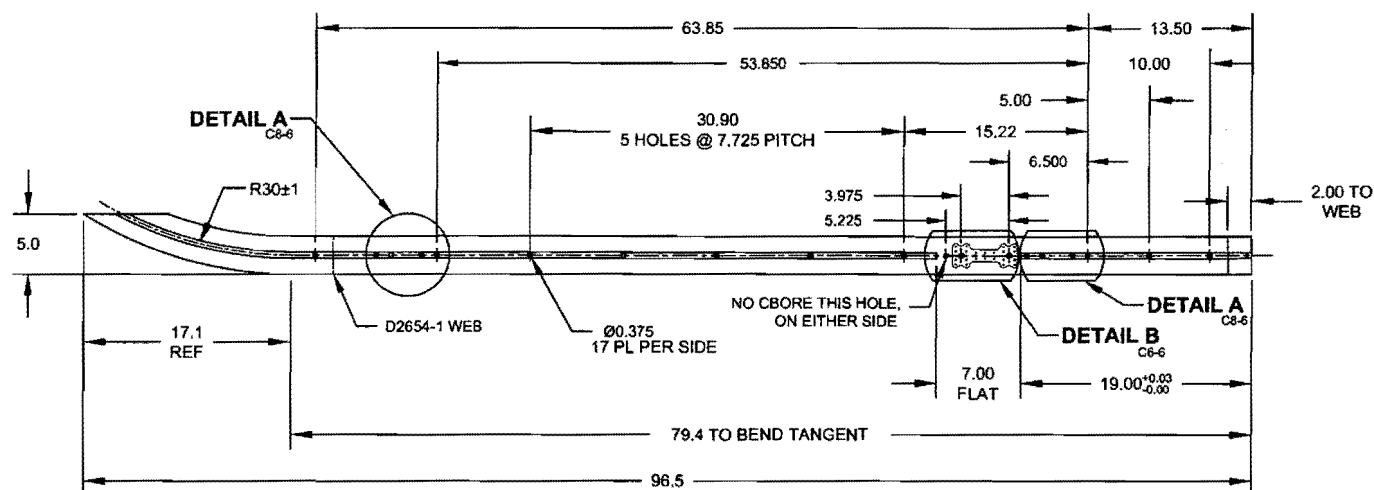
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

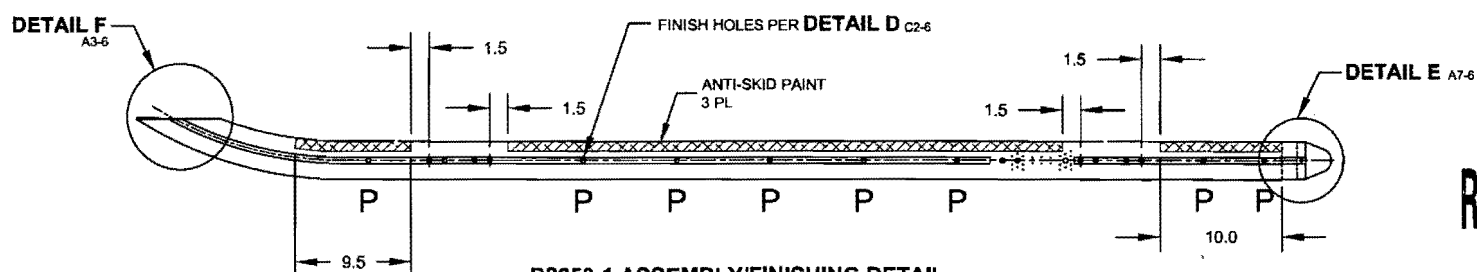
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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D2650-1 BENDING/DRILLING DETAIL



D2650-1 ASSEMBLY/FINISHING DETAIL

u/o 67153

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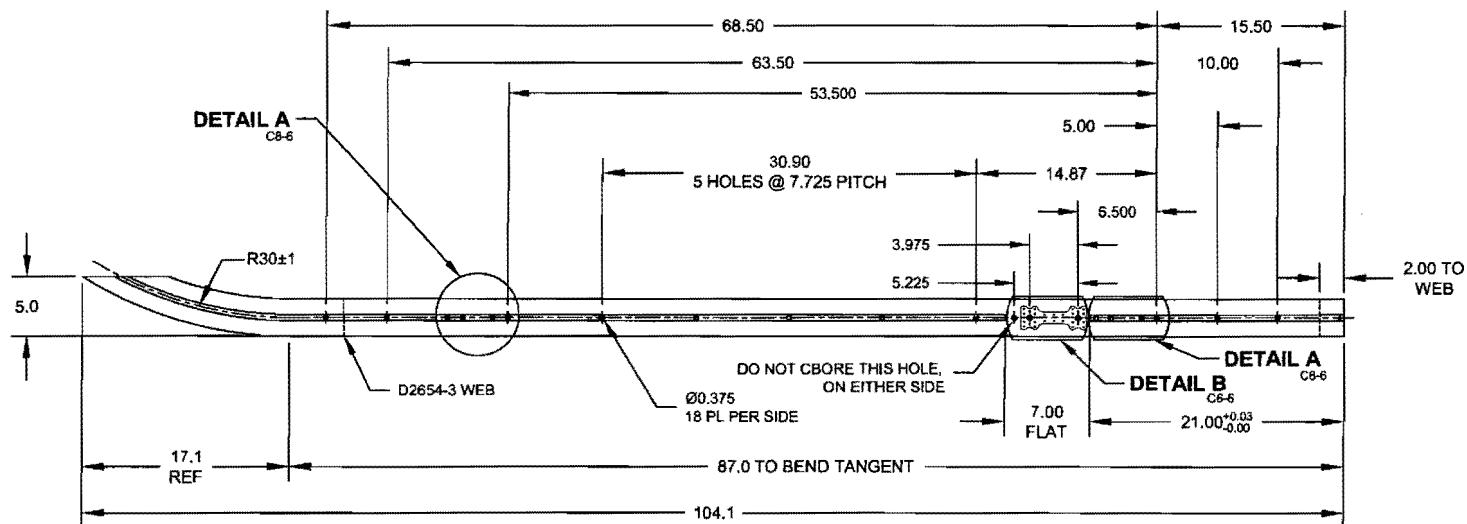
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

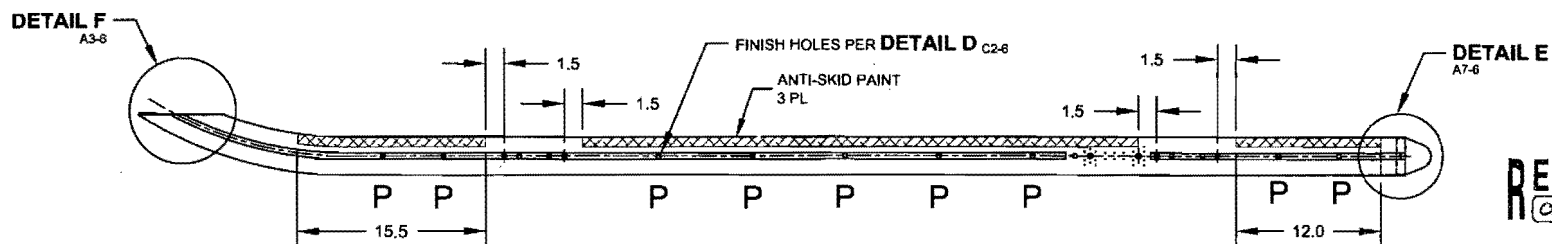
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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D2650-3 BENDING/DRILLING DETAIL

u667153



D2650-3 ASSEMBLY/FINISHING DETAIL

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MFG. APPR.	E	D2650	SHEET 3 OF 6
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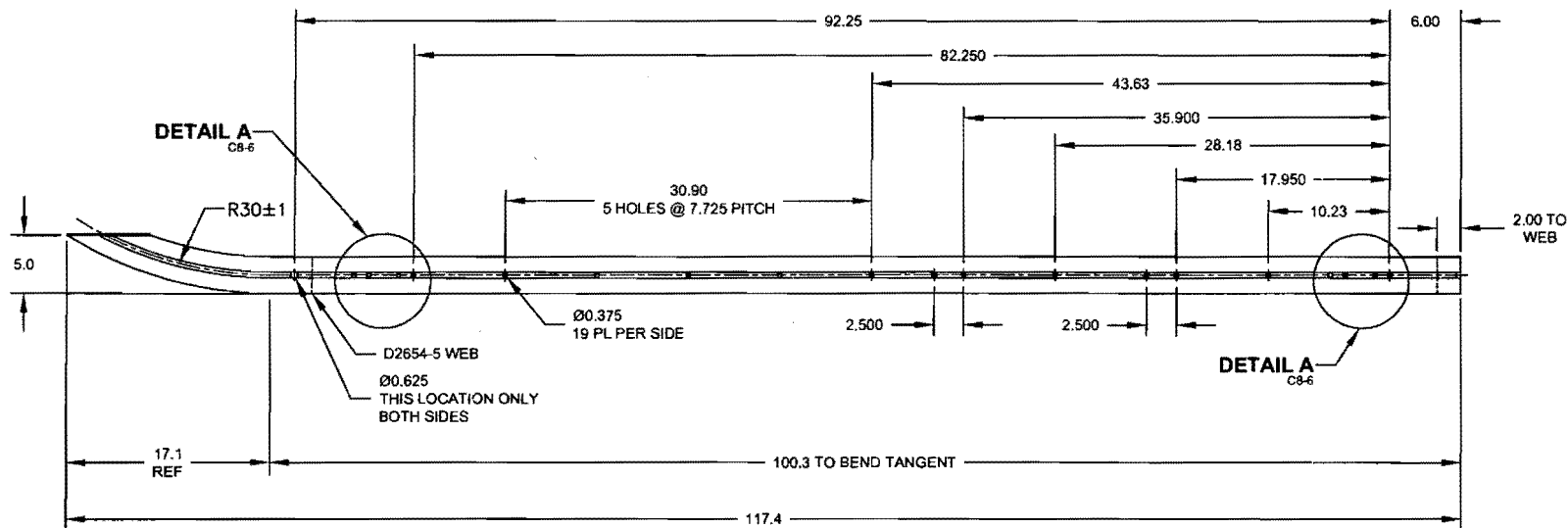
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

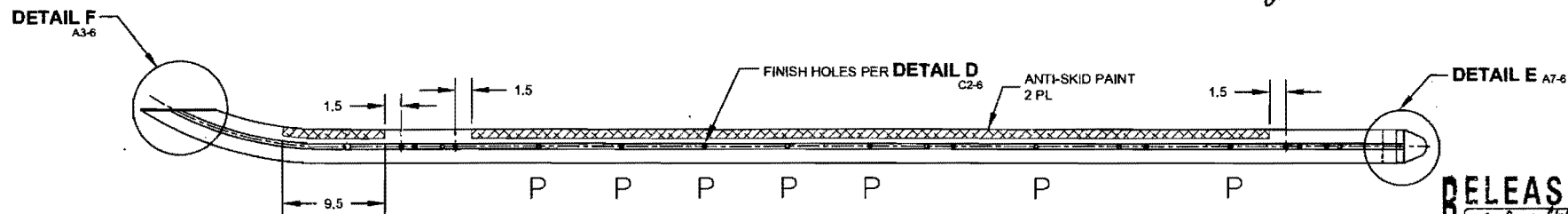
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D2650-5 BENDING/DRILLING DETAIL



D2650-5 ASSEMBLY/FINISHING DETAIL

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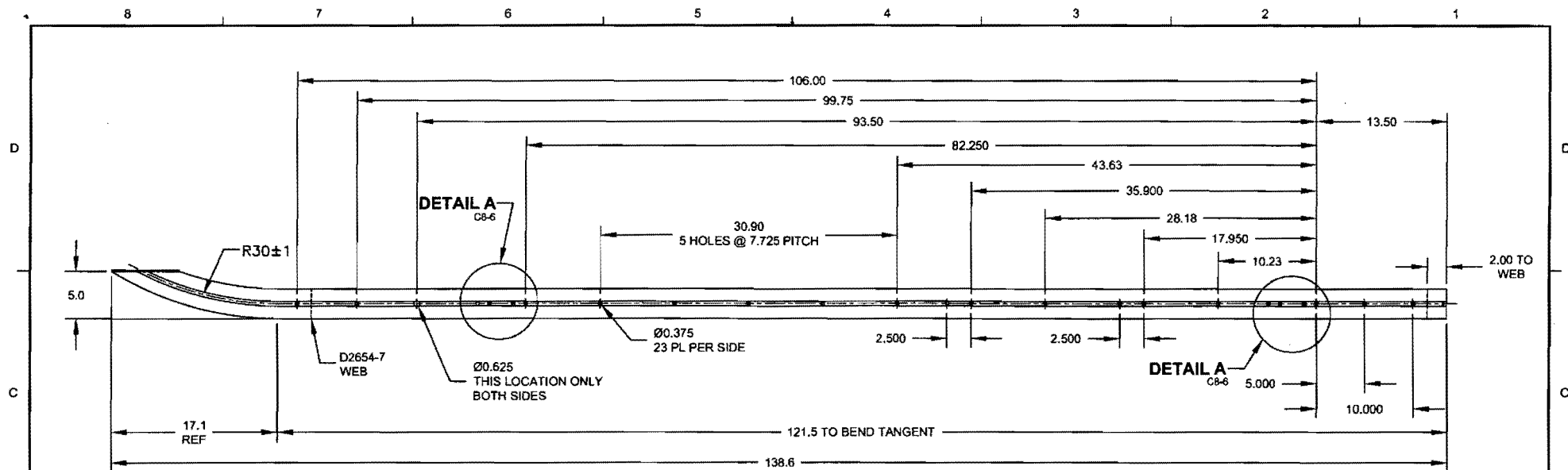
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

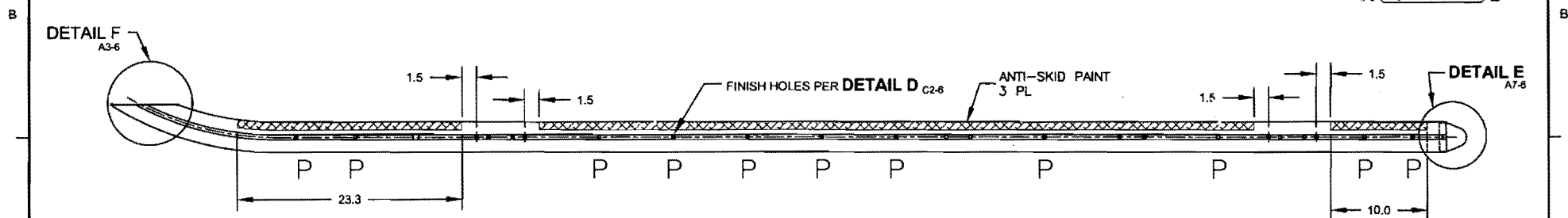
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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D2650-7 BENDING/DRILL DETAIL



D2650-7 ASSEMBLY/FINISHING DETAIL

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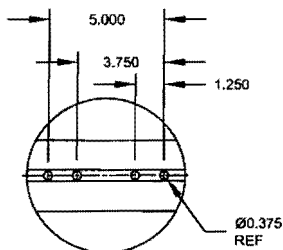
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

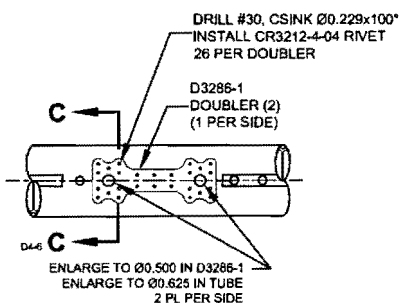
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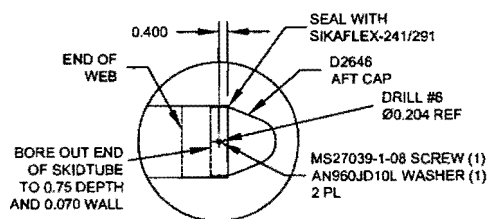
DETAIL A
SCALE 2X

C2-2
D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D6-5



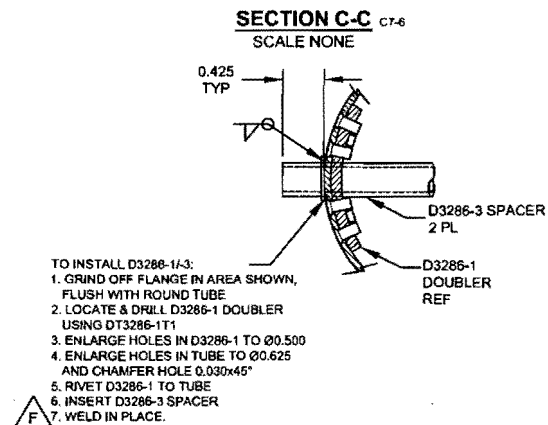
DETAIL B
SCALE 2X

C3-2
C3-3

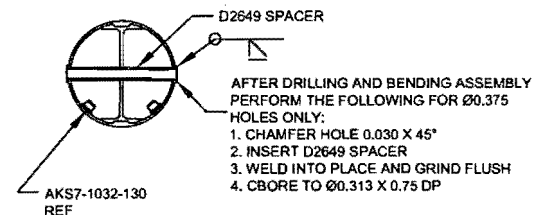


DETAIL E
SCALE 2X

B2-2
B2-3
B1-4
B1-5

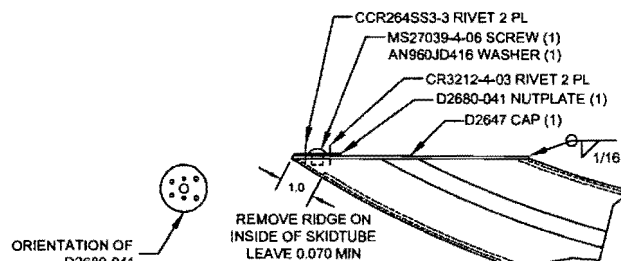


F



DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X

B4-2
B4-3
B4-4
B4-5



DETAIL F
SCALE NONE

B6-2
B6-3
B6-4
B6-5

- DETAIL F NOTES:**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2647 (TRIM AS NECESSARY)
 4. WELD D2647 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D2680-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

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